

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-014097**Date Inspected:** 12-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yu Dong Ping, Yu Qi Guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY11

TOWER STRUT PLATE

SMAW welding of weld joint 9B located on ND1-STSA4-6-127M-1.

Welder is identified as 040724. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-2212-Tc-U5b.

SMAW welding of weld joint 7A located on ED1-STSA4-10-119M-2.

Welder is identified as 044551. ZPMC QC is identified as Mr. Mao Bin Bin.

The welding variables recorded by QC appeared to comply with WPS-B-T-3212-Tc-U5b-1.

BEARING STIFFENER ON WD1-A25 SHEAR PLATE

FCAW welding of weld joint 46 located on WD1-A25B/E.

Welder is identified as 049541. ZPMC QC is identified as Mr. Shao Hui Long.

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The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

FCAW welding of weld joint 30 located on WD1-A25B/E.

Welder is identified as 053316. ZPMC QC is identified as Mr. Shao Hui Long.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

BEARING STIFFENER ON SD1-A23 SHEAR PLATE

FCAW welding of weld joint 34 located on SD1-A23A/B.

Welder is identified as 205649. ZPMC QC is identified as Mr. Zhang Lei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

During random in process verification of West Tower lift 3, this Quality Assurance (QA) Inspector discovered the welded end cap plate of BC and CD corner diagonal stiffener of West Tower lift 3 (top) has been removed by thermal cutting without approval of the engineer. As per AWS D1.5, section 3.7.5; The Engineer shall be notified before improperly fitted and welded members are cut apart. The green tag has been previously issued for this member. The members are located in Bay 11. This issue has an incident report.

Attached photographs provide additional detail.

BAY 10

BEARING STIFFENER ON WD1-A22 SHEAR PLATE

FCAW welding of weld joint 18 located on WD1-A22A/B.

Welder is identified as 057258. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

BEARING STIFFENER ON WD1-A28 SHEAR PLATE

FCAW welding of weld joint 25 located on WD1-A28A/B.

Welder is identified as 040367. ZPMC QC is identified as Mr. Sun Tian Liang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2331-Tc-P4-F.

NORTH TOWER LIFT 3, ELEVATOR BRACKET SUPPORT ON SKIN D

FCAW welding of weld joint 2-N located on Z69-0-C/F-32.

Welder is identified as 062259. ZPMC CWI is identified as Mr. You Qi Guo.

The welding variables recorded by QC appeared to comply with WPS-B-T-2332-Tc-P4-F.

TOWER FACADE PLATE

FCAW welding of weld joint 1 located on ND1-SFSA4-65.

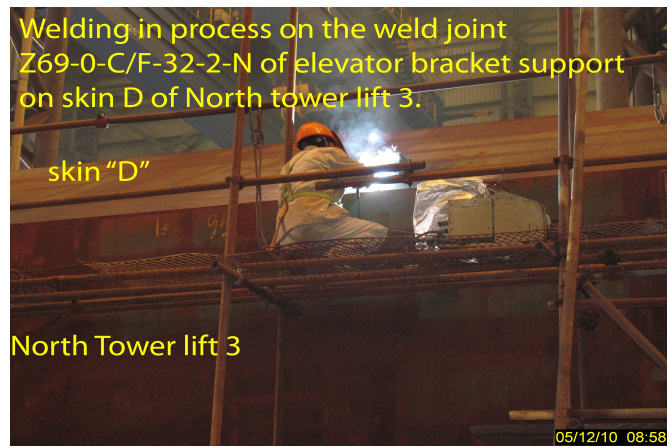
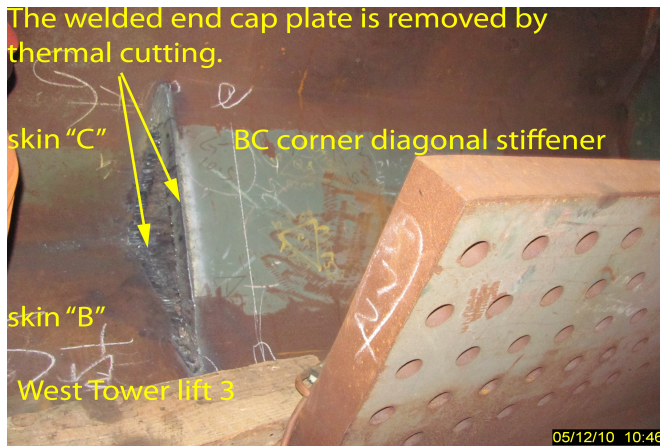
Welder is identified as 204868. ZPMC QC is identified as Mr. Zhu Zhong Jie.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Skyler Guest : 15000422360, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
